

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020164**Date Inspected:** 17-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

**OBG Segment Name:** OBG 7AE+7BE / Trial Assembly

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welders are identified as #220066 and #220067 welding complete joint penetration (CJP) welds in the 1G position using welding procedure specification WPS-B-T-223(2)1T-2. The welds are identified as OBE7-002, -003 and -004. ZPMC QC inspectors are identified as Mr. Zhang Xia Ming and certified welding inspector (CWI), Mr. Luan Zha Gang. The welding variables recorded by QC appeared to comply with the WPS.

**OBG Segment Name:** OBG 5BE DP-EP-E5 / Trial Assembly

This Caltrans QA inspector performed American Bridge / Fluor (ABF) Visual Testing (VT) and Ultrasonic Testing (UT) Verification Witness Request #01172010-2; Item #1 weld repair areas identified as SEG024\*-035 and 037 previously tested by ABF. QAMT was not performed due to the surface condition of the plate having coupling on it from ABF UT inspection. See Caltrans Ultrasonic Test Report (TL6027), date 01-17-2010 for additional information.

**OBG Segment Name:** Lift 1 Tower / Heavy Duty Dock

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #047736 welding partial joint penetration (PJP) weld in the 3G position using WPS-B-T-2333-TC-P4-F. The weld is identified as WSD1-SA225-F/H-55 on Skin E. ZPMC QC inspectors are identified as Mr. Sun Zi Wang and

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## WELDING INSPECTION REPORT

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CWI, Mr. Gong Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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